

85835

Page 1

Accept

N900040100

Setup Start *NS1*

Stop ***NS2***

6

Start Date: 15/06/2012 **Start Qty:** 6.00

Required Date: 29/06/2012 **Req'd Qty:** 6/00

6

Cust Item ID:

Customer:

Run Start *NR1*

Approvals: Process Plan: MLJ

Date: 12/06/15 Tooling:

Date:

QC:

Date: _____ SPC (Y/N): _____

Date:

Stop *NR2*

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 85835

June-15-12 1:34:56 PM

85835

Page 2

Item ID: D2938-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle LH Out, 206

Start Date: 15/06/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 29/06/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

3200F

900

DAS
14
2-83

12/07/18

10

4

10

76

12-7-18

10X

✓

MT

12/07/18

M121841

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 85835

June-15-12 1:34:56 PM

85835

Page 3

Item ID: D2938-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle LH Out, 206

Start Date: 15/06/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 29/06/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

10x d Ill 11/07/11

170

Identify as per dwg & Stock Location: 728A

0.00

170

Packaging

Memo

0.00

Packaging

(102) 12/2/18

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/7/18

mf
12-07-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-15-12 1:35:00 PM

Page 1

Work Order ID: 85835

85835

Parent Item: D2938-1

D2938-1

Parent Item Name: Saddle LH Out, 206

Start Date: 15/06/2012

Required Date: 29/06/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B 00.06.26 New DWG rev (mpp 2069)EC
IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	110.0000	1	6			

D6101-003

Saddle Billet, 7075

**

Location

Loc Qty

Loc Code

MAT040

66

73775

2

73780

7

78599

10

80765

0

85434

40

MAT042

43

81924

50

MAT044

1

73769

1

10

FK 12/07/12.

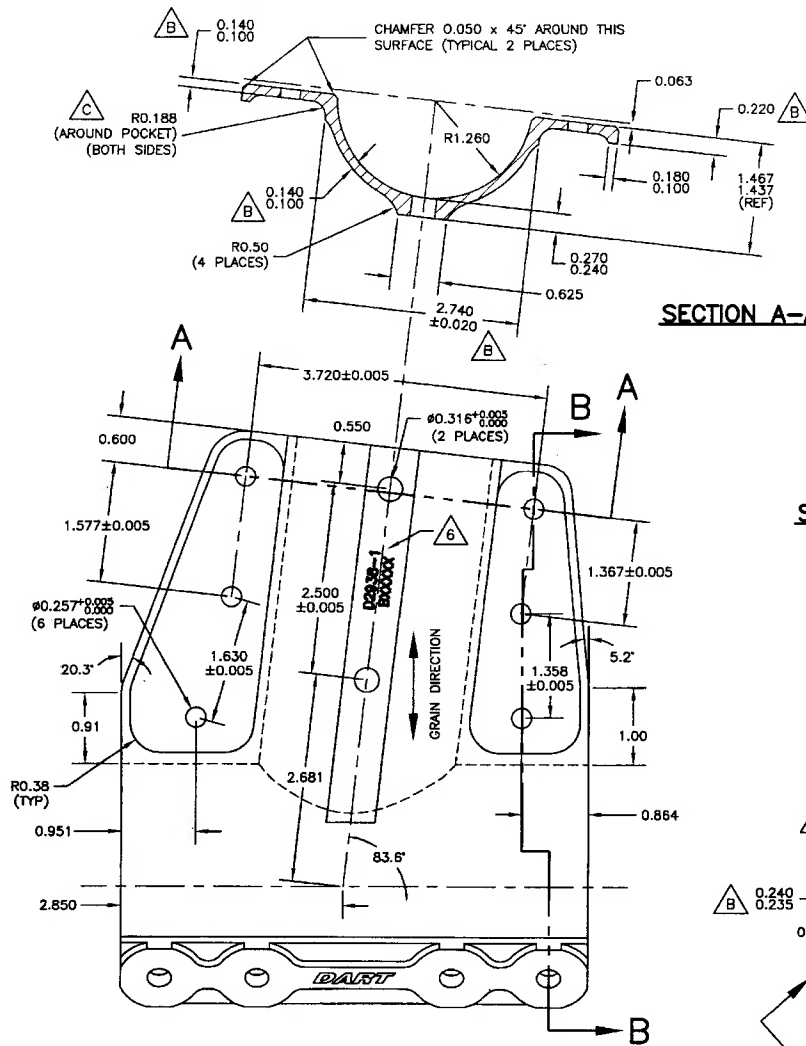
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SECTION A-A

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

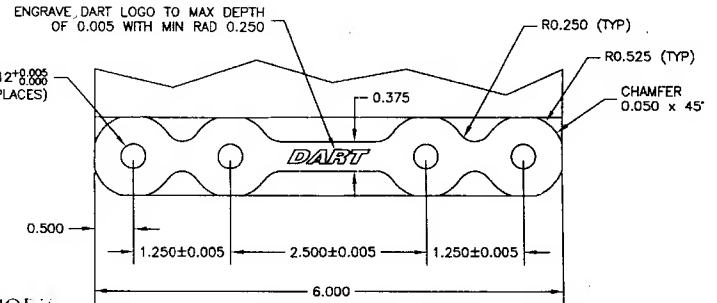
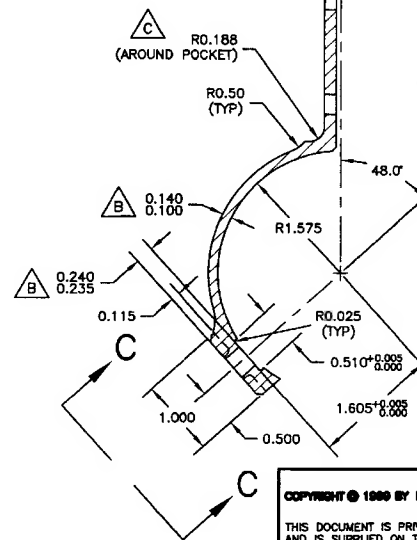
WITHOUT NOTICE

WORK ORDER

NO. 85835

MLJ
12/06/15

SECTION B-B



VIEW C-C

D2938-1 LH SADDLE (SHOWN)
D2938-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12) (MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	CB	DART DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	PH	DRAWING NO. D2938
DATE	06.11.09	TITLE SADDLE OUTSIDE
		REV. C SHEET 1 OF 1 SCALE 2:3

COPYRIGHT © 1999 BY DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

07.02.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 85835
Description: 206 Saddle, Outboard, Left side		Part Number: D2938-1
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.110	.114	.114	.114		
B	0.100	0.140		.112	.114	.112	.113		
C	0.100	0.140		.116	.113	.115	.114		
D	0.210	0.230		.223	.223	.221	.219		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.577	1.578	1.578	1.578		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.314	.314	.314	.314		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.120	.122	.122	.117		
O	0.540	0.560		.548	.551	.550	.5505		
P	0.490	0.510		.500	.502	.502	.501		
Q	3.715	3.725		3.720	3.721	3.718	3.718		
R	2.720	2.760		2.740	2.740	2.740	2.740		
S	0.240	0.270		.251	.251	.250	.250		
T	0.100	0.180		.135	.135	.135	.135		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.3665	1.367		
W	0.316	0.321		.317	.317	.317	.317		
X	1.250	1.270		1.260	1.2625	1.2618	1.2575		
Y	1.565	1.585		1.575	1.5755	1.5761	1.572		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	FK.
Date:	12/07/12 / 12/07/14

Audited by:	DAS
Date:	12/07/18

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order: 75835
Description: 206 Saddle, Outboard, Left side	Part Number: D2938-1
Inspection Dwg: D2938 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	5 X	6 X	7 X	8 X		
A	0.100	0.140		.116	.113	.116	.112		
B	0.100	0.140		.112	.112	.114	.112		
C	0.100	0.140		.115	.115	.115	.115		
D	0.210	0.230		.226	.220	.220	.220		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.578	1.578	1.578	1.578		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.314	.314	.314	.314		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.119	.119	.118	.119		
O	0.540	0.560		.550	.550	.550	.551		
P	0.490	0.510		.502	.502	.500	.502		
Q	3.715	3.725		3.720	3.720	3.718	3.720		
R	2.720	2.760		2.740	2.740	2.740	2.740		
S	0.240	0.270		.250	.250	.250	.251		
T	0.100	0.180		.135	.135	.135	.135		
U	1.625	1.635		1.629	1.631	1.628	1.629		
V	1.362	1.372		1.366	1.368	1.366	1.367		
W	0.316	0.321		.317	.317	.317	.317		
X	1.250	1.270		1.2588	1.2596	1.2589	1.259		
Y	1.565	1.585		1.5733	1.574	1.5735	1.574		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>SL</i>
Date:	12/07/14

Audited by:	DAS
Date:	12/07/14 ⁸⁹

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order: 85835
Description: 206 Saddle, Outboard, Left side		Part Number: D2938-1
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	9	102	3	4	By	Date
A	0.100	0.140		.115	.114				
B	0.100	0.140		.112	.113				
C	0.100	0.140		.115	.117				
D	0.210	0.230		.220	.220				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.510	.510				
I	1.572	1.582		1.578	1.575				
J	2.495	2.505		2.499	2.506				
K	0.257	0.262		.258	.258				
L	0.312	0.317		.314	.314				
M	0.235	0.240		.238	.238				
N	0.100	0.140		.118	.119				
O	0.540	0.560		.550	.550				
P	0.490	0.510		.501	.501				
Q	3.715	3.725		3.720	3.720				
R	2.720	2.760		2.740	2.740				
S	0.240	0.270		.251	.251				
T	0.100	0.180		.135	.135				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321		.317	.317				
X	1.250	1.270		1.2575	1.258				
Y	1.565	1.585		1.5728	1.573				
Z	0.178	0.198		.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>RF</i>	Audited by: <i>DAS</i>
Date: 12/07/15	Date: 12/07/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>